

Date: Monday, 3/19/2007 4:38:53 PM
 User: Kim Johnston

split 86 07/03/28

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 31302 -1	
Estimate Number : 11403	
P.O. Number : <i>N/A</i>	Part Number : D3296041
This Issue : 3/19/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3296 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30608	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 3/30/2007 Qty: <i>14</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. C 05/10/14 Added step 14 KJ/EC	
Est Rev:D Revised Steps 06-11-20 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D32961	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-1	Door Panel	<i>B30617</i>

FF 07-03-28 4

2.0	D32963	Door Panel
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Door Panel

Pick:

Qty	Part Number	Description	Batch
1	D3296-3 Door Panel		<i>B30618</i>

FF 07-03-28 4

3.0	D31617	Hinge 14"
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 14"

Batch: *B30612 x3* *B31340 ①*

FF 07-03-29 4

4.0	D31619	Hinge 17"
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hinge 17"

Batch: *B30613 x3* *B31341 ①*

FF 07-03-29 4

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MS20470AD44

Rivet, Universal Head



Comment: Qty.: 25.0000 Each(s)/Unit Total : 250.0000 Each(s)

Rivet, Universal Head

Batch: M102328

FF 07-03-29

4

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Fabricate & assemble as per Dwg D3296.

FF 07-03-29

4

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-29 (4)

8.0

POWDER COATING

POWDER COATING



M102316



(4X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

m-h 07/03/30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-04-09

(4)

10.0

D2137

Decal - No Step



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Decal - No Step

Pick:

Qty Part Number Description Batch

1 D2137 Decal B 31463

4

11.0

D2419

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

Pick:

Qty Part Number Description Batch

1 D2419 Handle B31424

mf 07-04-09

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D24620040

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0040 Seal

B29456 -

13.0

D24620053

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0053 Seal

B29456 -

14.0

D24620245

Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Seal

Pick:

Qty Part Number Description Batch

1 D2462-0245 (98) Seal

B29456 -

15.0

D27281

Dart Logo label small



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Dart Logo label small

Pick:

Qty Part Number Description Batch

1 D2728-1 Decal

B24215 -

16.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch

1 AN960JD6 Washer

m6085 -

MF 07-04-09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 31302

Part Number: D3296041

Job Number:



Seq. #:

Machine Or Operation:

Description:

17.0

MS20470AD46

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

1 MS20470AD4-6 Rivet

M102929 -

MF 07-04-09

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3296

MF 07-04-09 (4)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/04/10 Y

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/04/10 (4)

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/10 (4)

Job Completion



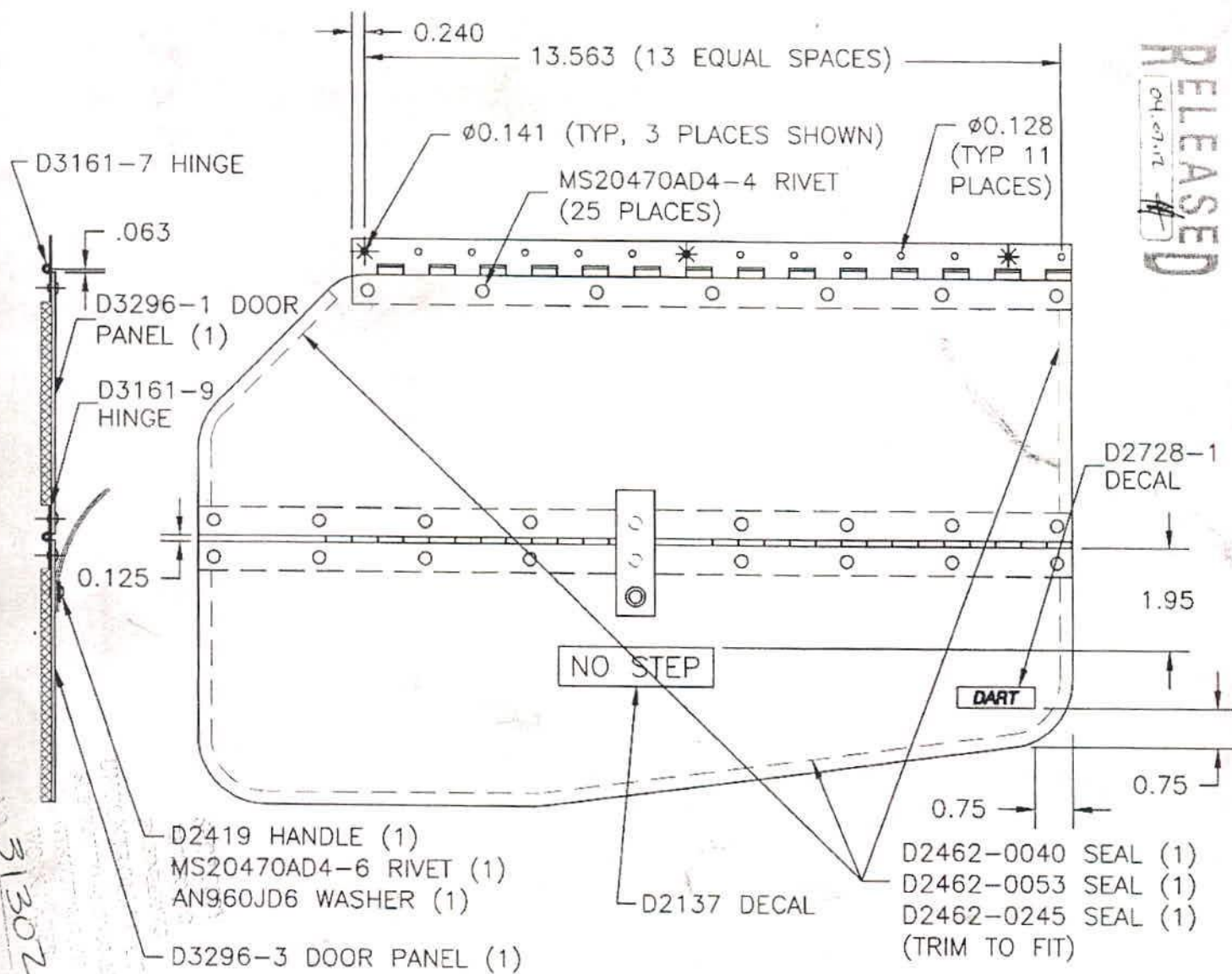
U 07-04-10

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
04.06.28	04.06.28	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04.06.28	04.06.28	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3

RELEASED
04.07.17



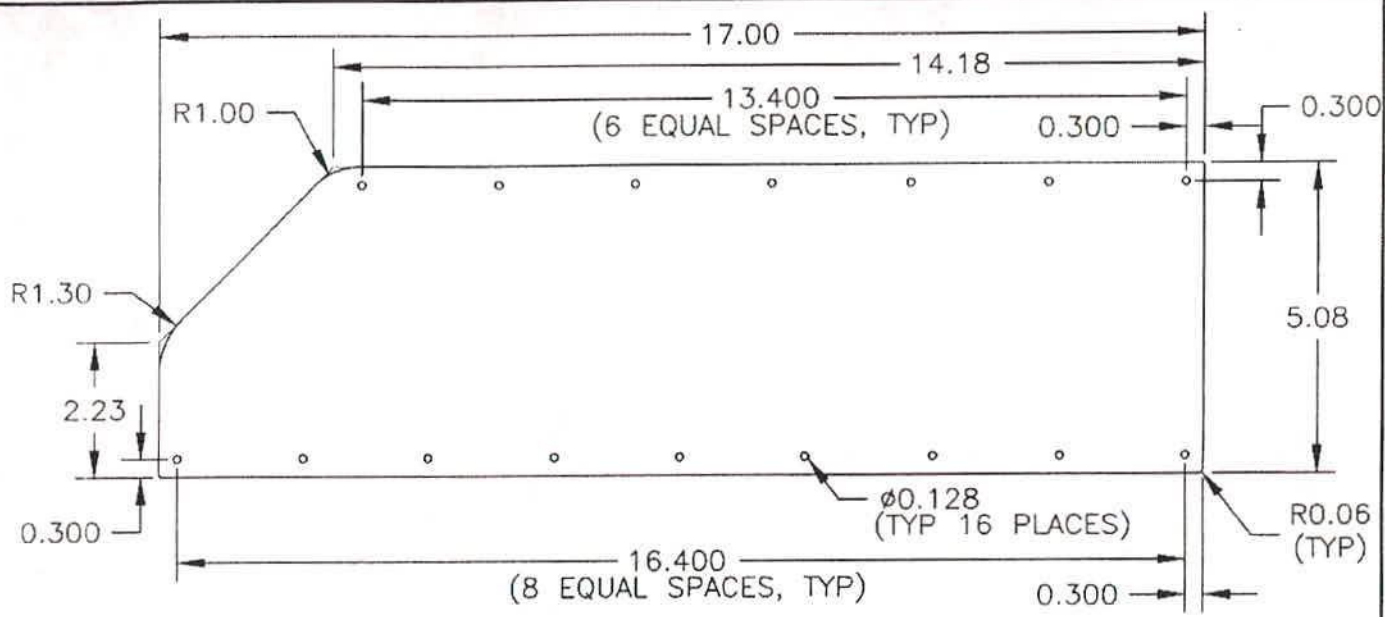
D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

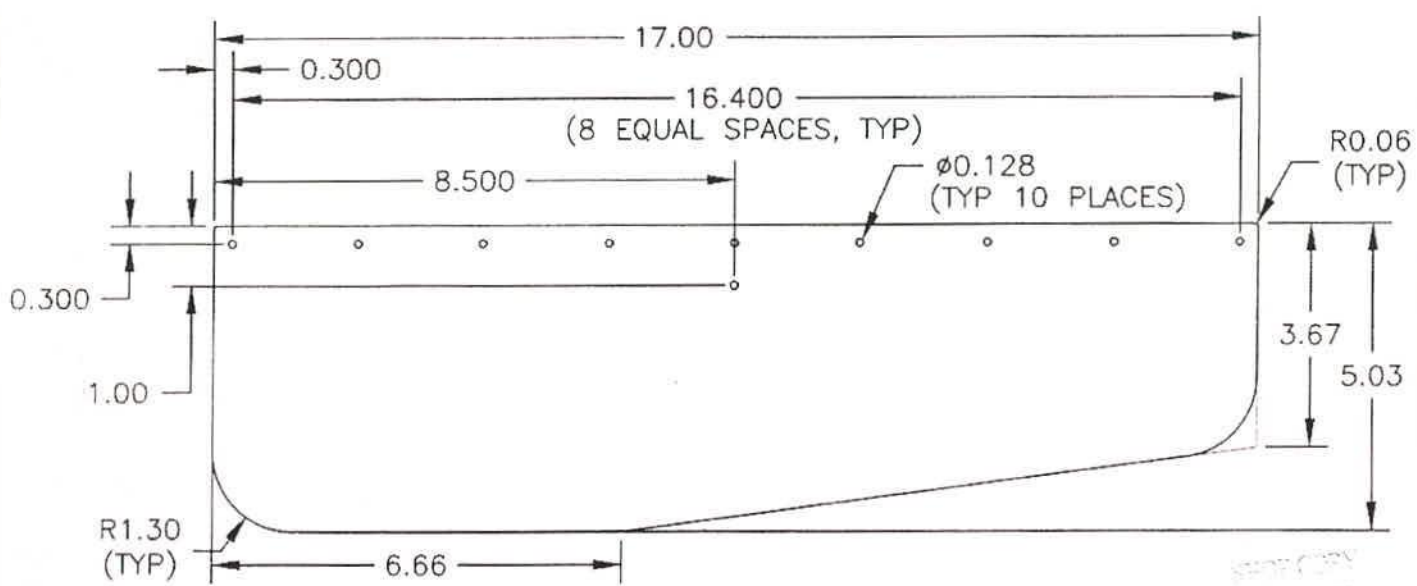
31302



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

31302

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.